

Date: Thursday, 17/08/2006 3:19:28 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : MIRROR BRACKET RH
<b>Job Number</b> : 28218A02	
<b>Estimate Number</b> : 10147	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D20132
<b>This Issue</b> : 17/08/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2013 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : C
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : <u>U</u>	<b>Due Date</b> : 14/09/2006 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>U</u>	
<b>Comment</b> : Est Rev:A New Issue 05-11-01 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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**Comment:** Qty.: 2.0447 f(s)/Unit Total : 8.1787 f(s)  
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing  
 (M304TR0.750W.049)  
 Batch: M100999

FF 06.08.30 4

2.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

- 1-Punch as per template D2013-T1and Dwg D2013
- 2-Flatten ends of D2013-2 tube as per Dwg D2013 using DT8545
- 3-Bend (1) tube as per Dwg D2013 using Jig DT8201Identify as D2013-2.
- 4-Deburr as required

FF 06.08.30 4

FF 06.08.31 4

FF 06.08.31 4

FF 06.08.31 4

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SB 06/08/34 4

Job Completion



Inspection level 21 06/09/06 4

U 06.09.06

**Dart Aerospace Ltd**

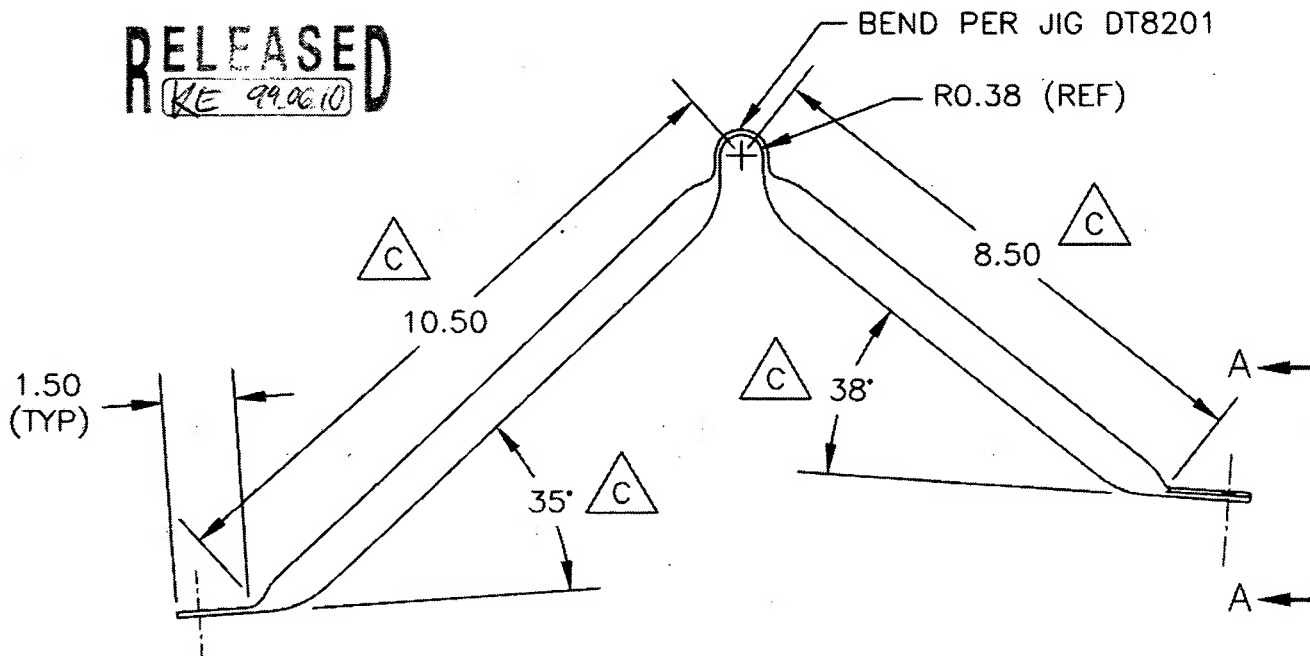
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 06/05/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

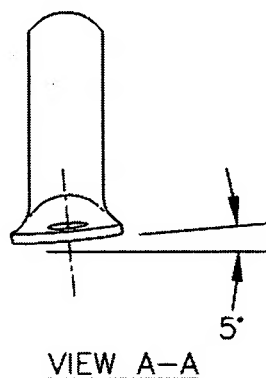
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED  
KE 99.06.10



D2013-1 LH SHOWN  
D2013-2 RH OPPOSITE  
(FOR 205 MIRROR)



DRILL  $\phi 0.257$  (TYP)  
0.400 (TYP)

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 OD x 0.049 WALL

REFERENCE ONLY

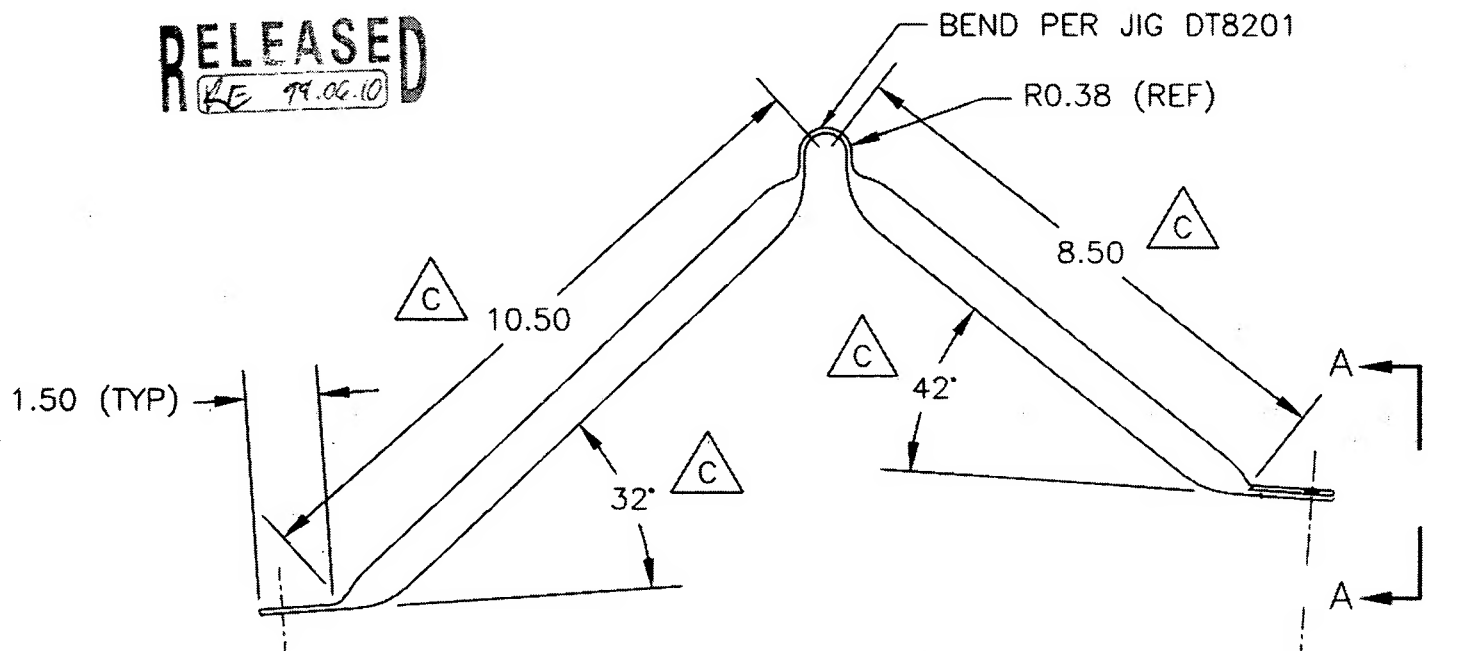
**DART**



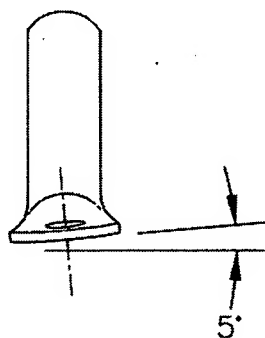
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JB	RF	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	JD	D2013
DATE	TITLE	REV. C
99.06.07	MIRROR BRACKET	SHEET 1 OF 3
A	NEW ISSUE	SCALE
B	REDRAWN	NTS
C	REDRAWN, CHANGE OF DIMENSIONS	

RELEASED  
RE 79.06.10

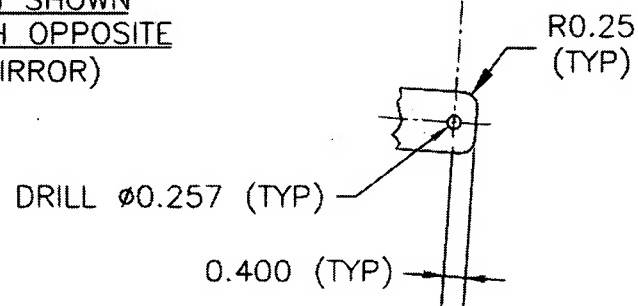
**DART**



D2013-3 LH SHOWN  
D2013-4 RH OPPOSITE  
(FOR 212 MIRROR)



VIEW A-A



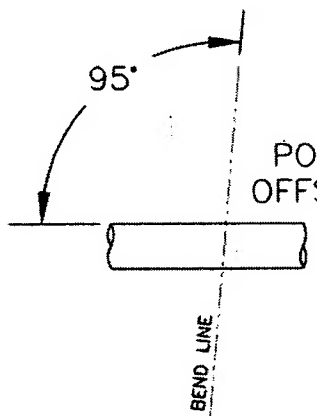
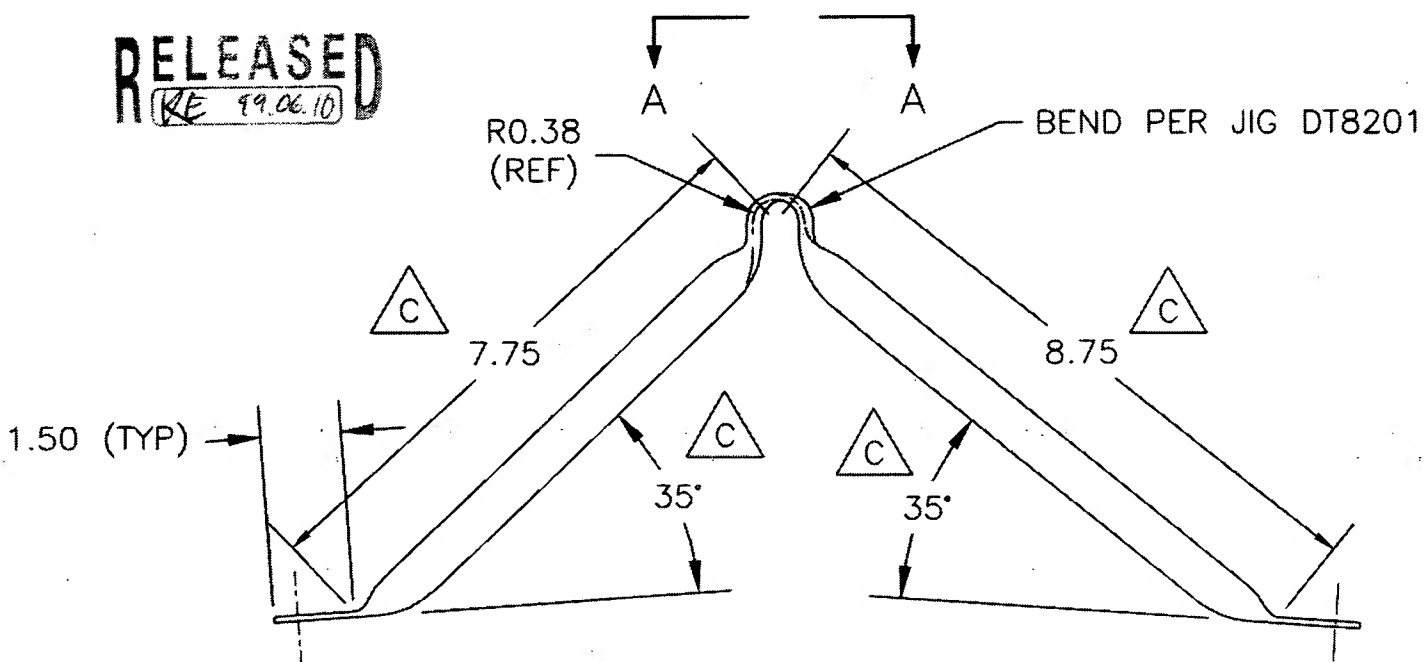
CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 O.D. x 0.049 WALL

DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	
DATE	99.06.07	DRAWING NO.	D2013	REV. C
TITLE	MIRROR BRACKET	SHEET 2 OF 3	SCALE	NTS

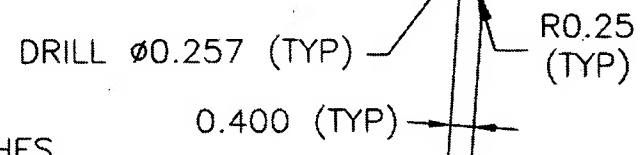
RELEASED  
KE 99.06.10

**DART**



POSITION TUBE  
OFFSET 5° IN JIG

D2013-5 LH SHOWN  
D2013-6 RH OPPOSITE  
(FOR 204 MIRROR)



CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 O.D. x 0.049 WALL

DESIGN	JB	DRAWN BY	KE	TITLE	MIRROR BRACKET
CHECKED	KE	APPROVED	KE	DRAWING NO.	D2013
DATE	99.06.07			SHEET	3 OF 3
				SCALE	NTS

DART AEROSPACE LTD  
HAMKESBURY, ONTARIO, CANADA